

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009005**Date Inspected:** 03-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Jia**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, M. Manikandan was present during the time noted above for observations relative to the work being performed.

OBG # TRIAL ASSEMBLY YARD

Segment: 1AAE – 1AE

Caltrans Quality Assurance (QA) observed flat sides of butt welded joints on B1, B3 and B4 locations of 1AAE to 1AE across transverse splice are more than 5mm in a length of 600mm centered over the weld joint. The readings are as follows

B1 – 7mm in a length of 600mm

B3 – 7mm in a length of 600mm

B4 – 7mm in a length of 600mm

Segment: 1AAW – 1AW

Caltrans Quality Assurance (QA) inspector observed the flat sides of a butt welded joint on the Bottom Panel (B2 1150mm towards B3) of 1AAW to 1AW. The out of flatness measurements were taken across the transverse splice, 7mm in a length of 600mm centered over the weld joint.

OBG # TRIAL ASSEMBLY YARD

WELDING INSPECTION REPORT

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This QA inspector witnessed final tension verification for lower chevron of 3AE. Witnessed 10% on a random basis the bolts and found the tension to be in general compliance. The panel point and bolt size designations are as follows:

PP-21: M22 X 75 - Total bolts: 18

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

The incident report is issued for the above mentioned discrepancy observed in 1AAW-1AW and 1AAE-1AE. And prior to issue it was informed to ZPMC QC and ABF QA.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Manikandan,Murugan	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
